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CENTRAL INTELLIGENCE AGENCY

INFORMATION REPORT

50X1-HUM

COUNTRY USSR

SUBJECT "Kalibr" Tool Shop, Buildings, Equipment, Production, and Administration

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50X1-HUM

"Kalibr" is one of four tool-making plants provided for in the first Five-Year Plan. Objective of the plan was to centralize all USSR tool production. The other three plants are (1) "Frezer" Plant in the southeastern suburb of Moscow (producing cutters); (2) one drill-making plant; and (3) one cutting-tool making plant. [redacted] the drill-making plant is in Kiev and the cutting-tool making plant is in Gor'kiy. The "Kalibr" plant is located in the northern part of Moscow, near the suburb of Rostokino, within a semi-circle formed by the railroad lines.

50X1-HUM

3. According to the "Plan" cost of the plant was set at 50 million rubles. Construction started in 1931; by 1932, buildings 1,2,3,4,5,8,9,10,11,12,16,17, and 18 were completed (See Table I Enclosure (A)) and the plant began operation while the finishing shop was located temporarily in building No 2.

4. The plant was in a state of "breakdown" for two years and could not produce. In 1933 and 1934, building No 6 was built (finishing shop), and the plant started to produce.

5. As a result of the haste with which the plant was built, poor quality of building materials, and orders from the central authorities to save building materials, the wooden ceilings started to rot. The ceiling of building No 4 was rotted all the way through by 1935 and was replaced by a ceiling of reinforced concrete.

6. Production. The plant produced limit gauges, micrometers, inside caliper guages, Johanson blocks, and other precision measuring tools.

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7. Source of Equipment. All metal-working machine tools and laboratory equipment (absolute and relative interferometers, etc) were received from Germany. Boilers, transformers, pumps, ventilators, pneumatic pumps and compressors were Soviet-made. The universal turning lathe was also Soviet-made, a DIP type, produced by the Serp i Molot Plant in Moscow.

8. Production process. Stamping in Shop No 1, mechanical processing in Shop No 2, thermic processing (hardening and tempering) in Shop No 3, and complete finishing (partly mechanical and partly by hand) in Shop No 6 /See Table I Enclosure (A)/

9. Plant bottleneck. The bottleneck of the plant has always been a lack of qualified workers, mainly for hand-made finishing.

10. Plant stamp

11. Inspection. A special "Section of Technical Control" existed in the plant. The head of that section was placed directly under the plant director.

12. Administration Chart /See Table II, Enclosure (B)/

13. Material supply of the plant. High-quality tool steel was supplied by one of the Moscow plants (very small quantity).

14. Power sources.--High voltage electric current was supplied by the Moscow network. The network draws its current from a series of power plants: the Moscow MGES /Hydroelectric Power Station/ which operates on coal, the Kashira Plant which operates on turf, etc. Power is brought to the transformer station by two cables from opposite ends of the plant. From the transformer a 220/380 volts current is distributed to the shops through underground cables.

15. Gas comes from the Moscow gas network through an underground pipe (approximately eight inches in diameter) Water comes from the Moscow city network.

16. A special fire-prevention network operates from pumps located in building No 10. Pressure (seven atmospheres) supply is from underground tanks in building No 11. In case of interruption in the city water supply, an artesian well is used (building No 18). This well is operated on compressed air (MAMUT system - airlift pump).

17. Dwellings. Houses were built for workers and employees of the plant. All houses are five-story buildings with three-room-and-kitchen apartments. The walls are made of brick, 1½ bricks thick. Beams and floors are of wood. There is running water, sewage, and electricity. The buildings must be completely dilapidated at the present time.

18. Plant sewage system. The sewage system is double. Rain water is drained through concrete pipes to the railroad ditch. Dirty water is drained through ceramic pipes to the city sewage system.

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Enclosure (A): Table I - Buildings of the "Kalibr" Tool Shop
Enclosure (B): Table II- Administration Chart

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50X1-HUM

ENCLOSURE (A)

TABLE I

BUILDINGS OF THE "KALIBR" TOOL SHOP

Building No.	Function	Equipment	Construction
1	Forge shop	Small hammers and presses	Brick-wall, wood-trusses and roof, reinforced-concrete crane girder
2	Preparatory shop (mechanical)	Precision automatic machines	Reinforced concrete columns and girders, wood beams and roof
3	Thermic hardness shop	Gas furnaces oil basins	Brick-wall, reinforced concrete arches, and reinforced concrete floor (beams and slab)
4	Thermic hardness shop	Pumps, fans, lab	Brick-wall, wood-beams and roof
3a	Ditto with a basement	All piping (gas, pres air, water etc) pumps, air-compressor	Concrete floor, reinforced concrete columns
5	Toilets and office of plant	None	Brick-wall, wood beams wood roof
6	Finishing plant	Small precision machines and benches for hand work	Reinforced concrete columns, beams, girders and slabs 4-stories
7	Toilets and office of plant	None	Brick-walls, wood beams and floors, reinforced concrete girders 5-stories
8	Repairing and tools shop	Lathes, drills, etc	Brick-wall, reinforced concrete columns and girders, wood beams and roof
9	Electric sub-station	Oil transformer 10,000 V to 380/200 V.	Brick wall and reinforced slab
10	Pump station (water) air-compressor	Water pumps 7 atmospheres	Brick-walls wood roof
11	Water basins below grade elevation	None	Reinforced concrete and ceiling
12	Boiler house	2-Boiler system "Shuhow"	Brick walls, wood trusses and roof
13	Storage (Magazine)	Future Building	
14	Main Office		
15	Lab.		
16	Factory School	-	Brick walls, reinforced concrete girders, wood-beams and floors 3-story building
17	Apartment houses	-	Brick and wood 5-story buildings
18	Artesian bore-well	Air-lift pump	-

50X1-HUM

ENCLOSURE (B)

ADMINISTRATION CHART